Date Uśer: Prsht Rev. First Issue Previous Run Written By Comment

Monday, 2/11/2008 2:12:41 PM

Kim Johnston

**Process Sheet** 

**Drawing Name** 

Part Number

**Drawing Number** 

Project Number

**Drawing Revision** 

Customer : CU-DAR001 Dart Helicopters Services

Job Number : 37352 **Estimate Number** : 12716

P.O. Number

: 2/11/2008 This Issue

: NC

: //

: 36609

Checked & Approved By

: Est Rev:A

Type

S.O. No. :

: SMALL /MED FAB

New Issue 07-02-14 JLM

Material **Due Date** 

: 2/18/2008

: N/A

: A

: GASKET

: D353635

: D3536 REV A

Qty:

20 Um:

Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

NEOPRENE SHEET 0.063

1.0

MNEO60S063

0.6507 sf(s)/Unit

17

Total: 13.0137 sf(s)

**NEOPRENE SHEET 0.063** 

Batch: 106614

2.0

WATER JET

Comment: Qty.:

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3536

Dwg Rev:\_ Prog Rev:\_\_\_

B 8-2-12

2-Deburr if necessary

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



4.0 QC8

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SECOND CHECK



Comment: SECOND CHECK

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:\_





W/O:			i .	WOR	K ORDER CHAN	NGES					
DATE	STEP		P	ROCEDURE CHANG	SE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		!	1								
		4	İ								
41			İ								
									-		

Part No:		PAR #:	Fault Category:	 NCR: Yes No DQA:	<u> </u>	12 17
	1			OA: N/C Closed	Data	

NCR:				ER NON-CONFORMAN		T		T
DATE	CTED	Description of NC		Corrective Action Section E		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspecto
		i I				,		
		İ				-		
		1	1					
						'		
-								
								:
		3.						

NOTE: Date & initial all entries

Date:

Monday, 2/11/2008 2:12:41 PM

User:

Kim Johnston

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 37352

Part Number: D353635

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mi 2000/2/13



# 

		WORK ORI	DER NON-CONFORMAN	CE (NCR)			
	Description of NC		Corrective Action Section B	3	Verification	Approval	Approval
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector
			(v)				1
					4		
	STEP	STEP Description of NC Section A	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP   Description of NC   Initial   Action Description   Sign & Section C	STEP Description of NC Section A Portion Description Section B Sign & Verification Section C Chief Eng

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 373	52
Description: Gasket	Part Number: D353	6-35
Inspection Dwg: D3536 Rev: A	Page 1	of 1

### FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
23.25	+/-0.030	23.75	*			
19.75	+/-0.030	19.75	*			
17.75	+/-0.030	17.75	*			
14.25	+/-0.030	14.95	×.			
9.50	+/-0.030	9.50	*			·
4.75	+/-0.030	4.75	æ			
2.00	+/-0.030	2.00	*			
6.00	+/-0.030	6.00	*			
6.75	+/-0.030	6,75	×	,		
0.30	+/-0.030	.302	<b>x</b>			
0.30	+/-0.030	,302	<mark>አ</mark>			
1.89	+/-0.030	1.89	×			
Ø0.19	+0.005/-0.001	,19	*			
0.063	+/-0.010	, 064	¥			
					-	

Measured by: B Audited by: U Prototype Approval: N/A

Date: 8-3-12 Date: VS(U)(2 Date: N/A

Rev	Date	Change	Revised by	Approyed
Α	07.03.14	New Issue	KJ/JLM	ad

20.50.12

DATE

CHECKED

 $\mathcal{Z}$ 

D3536 DRAWING NO.

SHEET

1 OF 6 REV. A

SCALE 1:10

B

DRAWN BY APPROVED

DART

AEROSPACE (

**J** 

NC.

06.10.25

GASKET

 $\triangleright$ 

06.10.25

NEW

ISSUE

26.65 23.15 17.65 13.40 - 0.90 - 5.65 1.89 DETAIL A 3.90 Ø0.19

D3536-11 GASKET

	70.00
	32.90
	27.40
	23.90
	18.98
	14.07
	9.15 0.90
	5.65
5)	DETAIL A - 3.90 - 3.90 - 1
	SHOP COPY SHOP COPY SHOP COPY RETURN TO RETURN TO RETURN TO RETURN TO AMENDMENT WORK ORDER WORK ORDER
NO.	SEC 13 CARVET
j	WITH SHOULD BE S
ļ	
	D3536—13 GASKET  SHOP COPY RETURN TO RETURN TO RETURN TO ANTENDING WITHOUT NOTICE WITHOUT NOTICE WORK ORDER
	10 E

뒾s

DOCUMENT

ᄶ

Copyright © 2006 by DART AEROSPACE USA, INC.

PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION, THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR "OR-COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE 3) PART IS SYMM

(TYP 3 PLS)

- 2) FINISH: NONE
  3) PART IS SYMMETRICAL ABOUT &
  4) TOLERANCES ARE PER DART QSI 018 UNLESS
  OTHERWISE NOTED
  5) ALL DIMENSIONS ARE IN INCHES
  6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT
  PERMANENT INK MARKER
  7 FEED DAGE & CONTROLLED AND OFFERDALE
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

웊

ğ

DAT

07.02:12

STEP ST

Copyright © 2006 by DART AEROSPACE USA, INC.

PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

뷮S

DOCUMENT

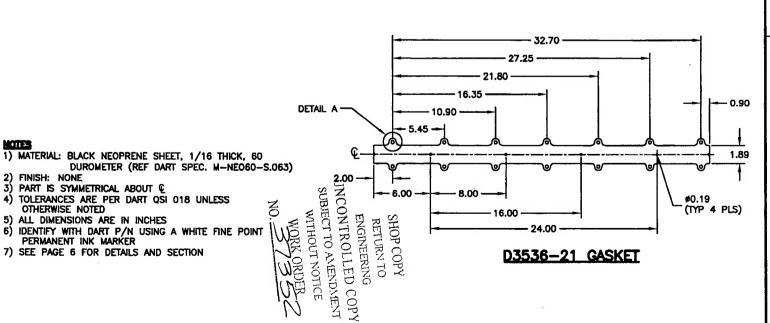
ℴ

2) FINISH: NONE 3) PART IS SYMM

PART IS SYMMETRICAL ABOUT ©
TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

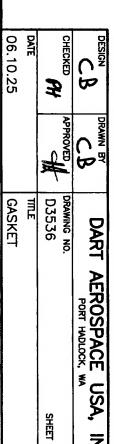
5) ALL DIMENSIONS ARE IN INCHES
6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
7) SEE PAGE 6 FOR DETAILS AND SECTION

39.15 35.65 33.65 30.15 24.90 -19.65 0.90 - 5.65 1.89 3.90 DETAIL A (TYP 4 PLS) 16.00 24.00 D3536-15 GASKET



CB CB	C B	DART AEROSPACE USA, INC.
ECKED	APPROVED []	DRAWING NO. REV. A
#	4	D3536 SHEET 2 OF 6
Æ		TITLE SCALE
6.10.25		GASKET 1:10

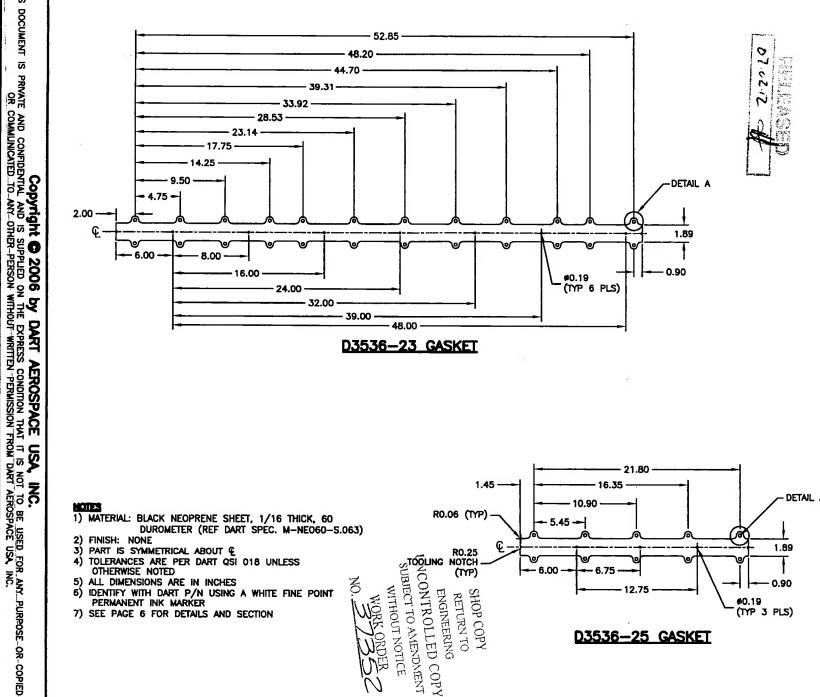


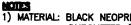


NC.

3 OF 6 REV.

SCALE 1:10





1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

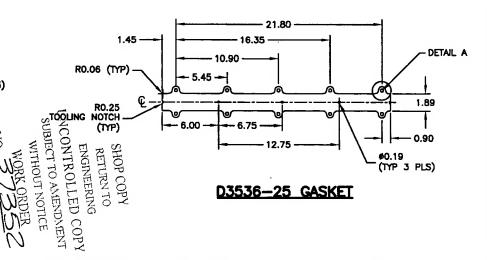
봀

DOCUMENT

ᇬ

2) FINISH: NONE
3) PART IS SYMMETRICAL ABOUT ©
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

7) SEE PAGE 6 FOR DETAILS AND SECTION



CHECKED

B

APPROVED

D3536

SHEET

**4** 우 REV.

SCALE 1:10

DRAWING NO.

DART

AEROSPACE PORT HADLOCK,

٤

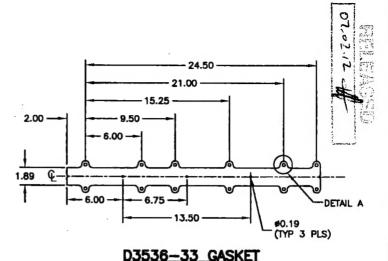
NC.

B

DATE

06.10.25

GASKET



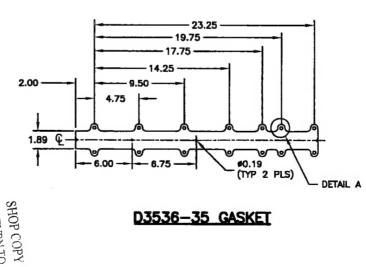
6.00 -Ç-1.89 #0.19 (TYP 3 PLS) D3536-31 GASKET

22.50

MOTES

2.00 ---

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- FINISH: NONE
- 2) 3)
- PART IS SYMMETRICAL ABOUT & TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
  IDENTIFY WITH DART P/N USING A WHITE FINE POINT
  PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-35 GASKET

SUBJECT TO AMENDMENT WITHOUT NOTICE UNCONTROLLED COPY RETURN TO ENGINEERING

DETAIL A

Copyright © 2006 by DART AEROSPACE USA, INC.

PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION\_FROM DART-AEROSPACE USA, INC.

ᠴ

DOCUMENT

 $\overline{\mathbf{v}}$ 

DESIGN

B

DRAWN BY APPROVED

DART

AEROSPACE (

USA,

NO.

CHECKED

B

DRAWING NO.

SHEET 5 OF 6

SCALE 1:10

REV. A

DATE

06.10.25

GASKET Ħ

01.02.12 

30.75 27.25 22.50 17.75 2.00 9.50 4.75 1.89 Ę - 6.00 8.00 16.00 DETAIL A 21.00 ●0.19 (TYP 4 PLS) D3536-37 GASKET

Copyright © 2006 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY-PURPOSE OR COPIED OR COMMUNICATED TO ANY-OTHER-PERSON-WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

NOTES  1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60		35.78 -29.28 -25.78 -23.25 -19.75 -17.75 -14.25 -9.50 -4.75	1.00
PERMANENT INK MARKER  7) SEE PAGE 6 FOR DETAILS AND SECTION  SUBJECT:  NO. 1		#0.19 (TYP 3 PLS)	1.88
DNTRC DWITHOU WORD O. WORD	RETU	SHOP 28.00	DETAIL A
	70 TO	면 Co	
D COPY NOVENT DER 2			

## 27.98 25.08 18.50 2.00 -3.43 1.88 4.00 #0.19 (TYP 2 PL\$) 3.90 DETAIL

D3536-41 GASKET

로S

Copyright © 2006 by DART AEROSPACE USA, INC.

DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

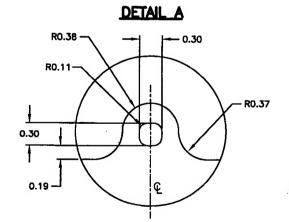
**PURPOSE** 

욹 COPIED

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

- 2) FINISH: NONE
  3) PART IS SYMMETRICAL ABOUT &
  4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  5) ALL DIMENSIONS ARE IN INCHES
  6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER





C B	DRAWN BY	DART AEROSPACE USA, INC.	S.
CHECKED	APPROVED //	DRAWING NO.	REV. A
#	#	D3536 SHEET	SHEET 6 OF 6
DATE		TITLE	SCALE
06.10.25		GASKET	1:10